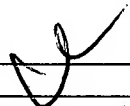
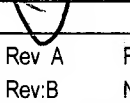


Date: Monday, 28/05/2007 9:08:16 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET LOCATOR
<b>Job Number</b> :	31923		
<b>Estimate Number</b> :	11230		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D23693
<b>This Issue</b> :	28/05/2007	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2369 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	31923	<b>Drawing Revision</b> :	A
		<b>Material</b> :	N/A
<b>Written By</b> :		<b>Due Date</b> :	05/06/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	10
<b>Comment</b> :	Est Rev A Removed from 9 Digit 05-12-05 JLM	<b>Um:</b>	Each
	Est Rev:B Now on Waterjet 07-05-28 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



**Comment:** Qty.: 1.4217 sf(s)/Unit Total: 14.2170 sf(s)  
 Material: 5052-H34 or H32 0.040" thick  
 (M5052H32S.040)  
 Batch: 414050

SAD 07/05/31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

SAD 07/05/31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/31

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

SAD 08/01/07 (+10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Deburr

SAD 08/01/07 (+10)

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

SAD 08/01/07 (+10)

Date: Monday, 28/05/2007 9:08:16 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 178

8/1/1

SP

(100%)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18  
D 08/01/08

Job Completion



Signature: [Handwritten Signature] 2007/1/7

W

PTD

Date: Tuesday, 4/17/2007 3:56:20 PM  
User: Kim Johnston

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET LOCATOR
Job Number	: 31923		
Estimate Number	: 11230		
P.O. Number	:	Part Number	: D23693
This Issue	: 4/17/2007 S.O. No. :	Drawing Number	: D2369 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 5/2/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>4/17/07</u>		
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM		

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



Comment: Qty.: 1.4217 sf(s)/Unit Total : 14.2170 sf(s)  
Material: 5052-H34 or H32.0.040" thick  
(M5052H32S.040)  
Batch: \_\_\_\_\_

*W. Keyes*

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR  
Cut blanks: 39.0" x 5.00

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D2369-3 as per Folio D2369-3 and Dwg D2369

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



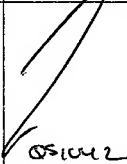
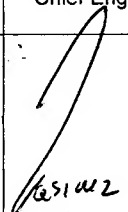
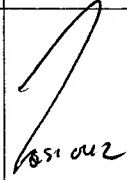
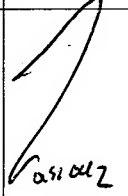

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

*4/28/07* (D)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/31	2.0	hole's on Part were to big had to change the offset E.C. Hammer error		Scrap destroy - replace Qty 1 part	SAD 07/06/18	Si 07/06/18		Ep 07/06/18
07/05/31	2.0	wrong mat. was used 0.050" thick instead of 0.040" mat.		<del>Parts</del> Parts are available	SAD 08/04/07	5 08		
		E.C. Hammer error						

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:56:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

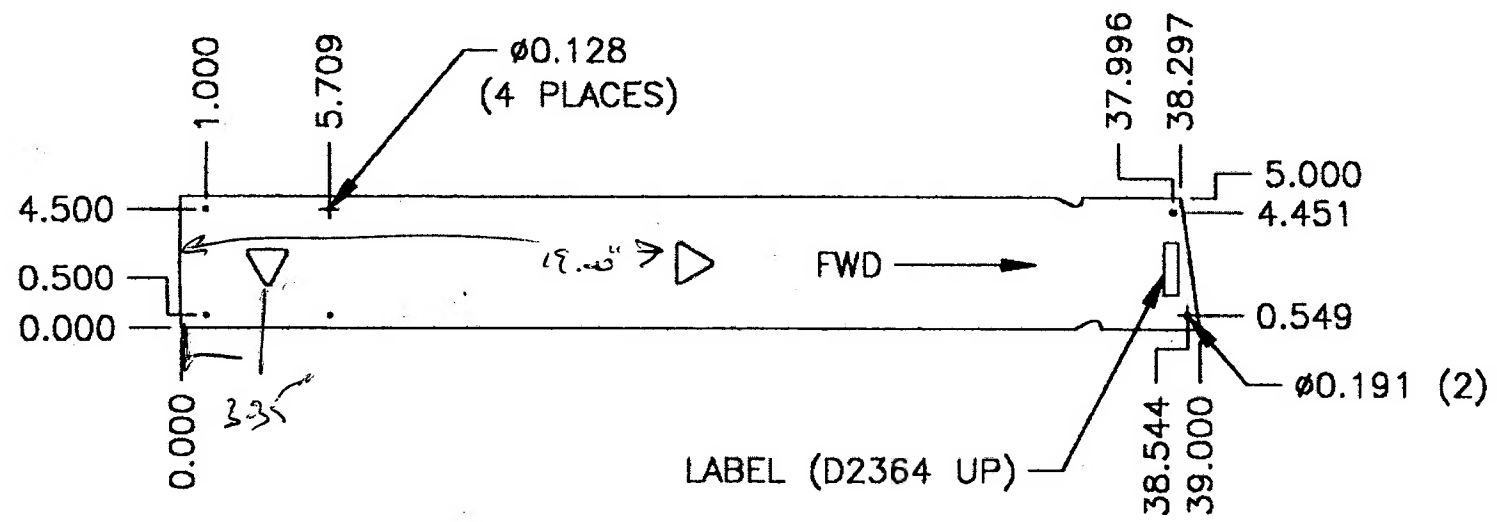
NOTE: Date & initial all entries





DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>B.W.</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2369
DATE	95:02:20	TITLE	DECK PLATE LOCATOR BRACKET	REV. A SHEET 1 OF 2
		SCALE	1:7	

RELEASED  
96 06 10



D2369-1

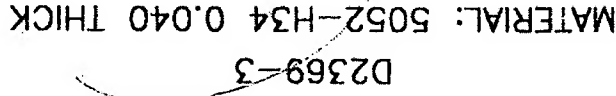
MATERIAL: 5052-H34 0.040 THICK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31923





RELEASED  
960610



WORK ORDER  
31923  
NO.